

Work Order ID 47742

June 26, 2009 12:24:34 PM

**PRELIMINARY ISSUE**

Page 1

Item ID: D119-646-243

Accept



Setup Start



Revision ID: Prelim

Stop



Item Name: Float Skidtube Assy With Training Wearplate

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

100



DC

Memo

0.00

0.00

Document Control

110



Skidtubes

Memo

0.00

0.00

Skidtubes

120



HandFinish

Memo

0.00

0.00

Hand Finishing

SEE ATTACHED w/o

Work Order ID 47742

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Page 2

Item ID: D119-646-243
Revision ID: Prelim
Item Name: Float Skidtube Assy With Training Wearplate
Start Date: 15/07/2009 Start Qty: 1.00
Required Date: 03/08/2009 Req'd Qty: 1.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N):

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC 3 Quality Control	Memo	0.00 0.00							
140 QC 5 Quality Control	Memo	0.00 0.00							
150 Skidtubes Skidtubes	Memo	0.00 0.00							

Work Order ID 47742

June 26, 2009 12:24:34 PM



Page 3

Item ID: D119-646-243
Revision ID: Prelim
Item Name: Float Skidtube Assy With Training Wearplate

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00



Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

Memo

0.00

0.00

170



Skidtubes

Skidtubes

Memo

0.00

0.00

MF 09-07-09

Date: Tuesday, 05/05/2009 2:12:16 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
Job Number :	47742		
Estimate Number :	13921		
P.O. Number :		Part Number :	D119646243
This Issue :	05/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3905 PRELIM
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	PRELIM
Written By :		Material :	
Checked & Approved By :	<u>MF 09-05-07</u>	Due Date :	12/05/2009
Comment :	Est Rev:A 09-04-30 new issue DD verified by:EC		

Additional Product

PRELIMINARY ISSUE ^{PH} 09.05.03

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 ✓	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D119-646-243 CHG001

N/A

2.0	D25001190	Ext'n - 'I' Beam Tube 4"
-----	-----------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Ext'n - 'I' Beam Tube 4"

batch: B40150

CERTIFICATE OF CONFORMITY
 REQUIRED

9-5-11

3.0 ✓	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1





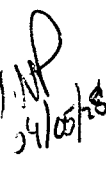

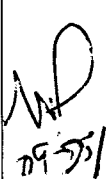
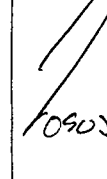


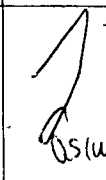

- 1- Bend FWD end of tube using Bender 1 and bend prog D3905 FWD per dwg D3905
- 2- Cut FWD end of tube as per dwg D3905.
- 3- Cut AFT end of tube as per dwg D3905.
 Remove inner ridge as per dwg D3905 Fwd + aft
- 4- Buff out marks left from bending
- 5- Drill Aft cap pilot hole using DT8149 ***DO NOT OPEN TO FINISHED SIZE***
 AFT CAP
- 6- Cleco DT8149 in position and install drill Jig DT _____ drill X-bolt spacer pilot holes using 3/16" drill
- 7- Spot drill holes to section G using #30 drill.
- 8- Drill FWD cap holes using DT8215. Open FWD & AFT cap holes to 0.208" → leave st cap holes @ 3/16

 IT
 07.09.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D119-646-243 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 47742		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0905-26	3.7	Upon the Assembly of A wear plate sig for Detail G, an actual wear plate was used instead of the "sig" wear plates. Holes, Qty 10 #30, are slightly off center. R.C: New process.		- sink the 10 affected holes & fill with weld per QSI 004, & grind flush.	BE 09/05/28			
0905-28	10.0	After bending the aft section, major material stretching was apparent on the bottoms of the aft end of the web. R.C: process.		- Tube is scrap but will be completed for testing purposes. - Process has been revised to bend Aft 1st, then install web, then bend fuel section.				
090606	14.0	Aft wear plate hole on the tube is too wide for the D3849-045 R.C: sig: prelim.		- Fill affected 2 holes with weld & grind flush. per QSI 004. - Transfer drill wear plate to tube. Another sig is being made.	BE 09/06/08			

NOTE: Date & initial all entries

Date: Tuesday, 05/2009 2:12:16 PM
User: Melanie H. teux

Process Sheet

Customer: CL-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #:

Machine Or Operation:

Description :

9- Drill FWD holes

10- Drill Tow ring hole using DT _____. Open to finished size.

AT 09-05-26

4.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

AT 09-05-26

5.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AT 09-05-26

6.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AT 09-05-26

ENGINEERING APPROVAL

7.0



SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt spacer holes to finished size ***DO NOT OPEN SPOT DRILLED HOLES IN SECTION G***

2-Deburr crossbolt spacer holes as per Dwg D3905 and blow out chips from inside the tube

AT 09-05-26

8.0



QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

N/A

9-5-26

9.0

D38853

Web, Float



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web, Float

batch: 47742

AT 09-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 05/05/2009 2:12:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bond web in place as per Dwg D3905 & QSI 015.

A/R Sikaflex-291

111081

Sikaflex expire date:

10-01-01

Start:

4:00

Time:

09-05-26

Finish:

8am

Time:

09-05-27

***** (Adhere for 12 hours) *****

2--Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Install drop pins in crossbolt spacer holes to maintain web position.

3- Buff out marks left from bending.

4- Open holes of section G (spot drilled holes) to finished size.

*****VERIFY DIMENSIONS*****

5- Countersink crossbolt spacer holes, and prepare tube for welding, deburr.

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

D39031

Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Spacer

batch:

47476

13.0

D36811

Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Spacer

batch:

46107

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert crossbolt spacers. Weld as per QSI 004 and Dwg D3905. Remember to back drill each hole before

Date: Tuesday, 05/05/2009 2:12:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #: Machine Or Operation: Description :

welding the other side. Use aluminum rod

A/R Aluminum Rod M111679 BE 09/05/28

2-Grind cross bolt welds flush as per Dwg D3905. Ensure no pin hole.

3-Counterbore 5/16" x 0.750" deep as per Dwg D3905.

4- Deburr & Scribe batch # on Aft end of tube.

Previous
Page 2

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

16.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 12:30pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:00pm

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0

D36833

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

batch: B477805

BR 09-06-19 (D)

Date: Tuesday, 05/05/2009 2:12:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AELS1032130

INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

batch: *M110511*

BR 09-06-19

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per Dwg D3905.

BR 09-06-19

23.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

D3905.19(1)

24.0

~~D2575~~

D2855-8

Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cap

batch: *B342343*

CP 09/06/19

25.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Phenolic Washer

batch: *B412329*

BR

26.0

D38461

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

batch: *B47806*

BR

27.0

D384611

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

batch: *B47807*

BR 09-06-19

Date: Tuesday, 05/05/2009 2:12:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D38471

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

batch: B481797

BR

29.0

D384711

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

batch: B47809

BR 09-06-19

30.0

D3849041

D3849-047

Fwd Wearplate Assembly, Std/Float Gear



Comment: Qty.: 1.0000 each(s)/Unit Total : 1.0000 each(s)

Fwd Wearplate Assembly, Std/Float Gear

batch: 50170

AN3C50A 05/06/19
bolt M112046 4

31.0

D3849045

Aft Wearplate Assembly, Float Gear



Comment: Qty.: 1.0000 each(s)/Unit Total : 1.0000 each(s)

Aft Wearplate Assembly, Float Gear

batch: B47811

05/06/19

32.0

D39041

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

batch: B48374

BR

33.0

D36723

Phenolic Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Phenolic Washer

batch: B341771

BR

34.0

AN3C4A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

batch: M112082

BR 09-06-19

34.5

D3411-3

Washer

B 00263

(16)

Date: Tuesday, 05/05/2009 2:12:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C5A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

batch: *M111707*

BR

36.0

AN3C46A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch: *M100196*

BR

* 37.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

batch: *M111808*

BR

38.0

AN960C416

washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

washer

batch: *M100993*

BR

39.0

MS210433

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

batch: *M111808 M111819*

BR

40.0

MS27039C408

SCREW



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

SCREW

batch: *M17831*

BR

41.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/R Sikaflex-240/-291

M111557

BR 02-06-19 ①

Date: Tuesday, 05/05/2009 2:12:16 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE

Job Number: 47742

Part Number: D119646243

Job Number:



Seq. #:

Machine Or Operation:

Description :

Sikaflex expire date: 10/01

2- install plugs assembly as per dwg.

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-240/-291

Sikaflex expire date:

5- Wong work as per drawing in 111013

BR 09-06-19

42.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

09.07.01

43.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and stock

Location:

X N/A for
chid

44.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE N/A FOR ENG USE (TESTING) ONLY

09/09/28

Job Completion



POSITIVE RECALL

EFFECTIVE

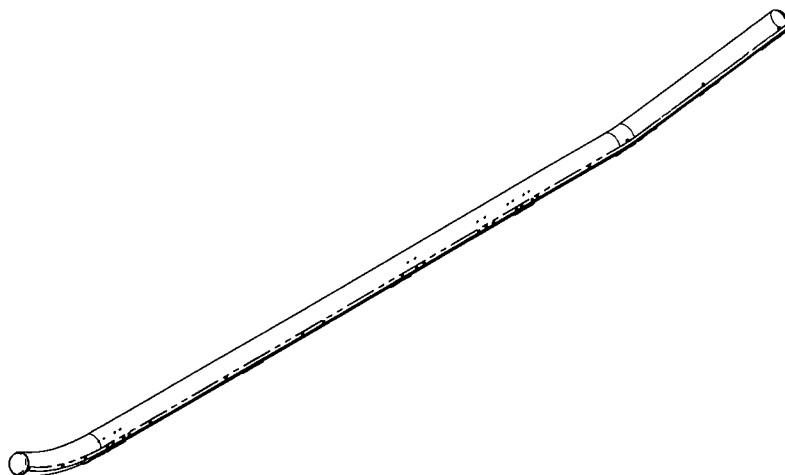
09.05.08 AUTH

RELEASED

DATE

MF
09-07-09

8 7 6 5 4 3 2 1



D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)
D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)
D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.2 lbs
D3905-043 = 46.5 lbs
D3905-045 = 46.8 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO Ø0.197 HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT _____ TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARPLATE INSERTS. INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2575	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-041	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
41	42	42	10	AELS-1032-130	INSERT
42	4	4	4	AN3C4A	BOLT
43	42	42	10	AN3C5A	BOLT
44			8	AN3C46A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

PRELIMINARY ISSUE
PH 09.05.03

A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	SS	D3905	SHEET 1 OF 8
APPROVED	MP	TITLE	SCALE
DE APPR.	TH	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.03.30	COPYRIGHT © 2003 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

BORE OUT END
OF SKIDTUBE TO
0.75 DEPTH TO FIT
D2575 CAP TO MIN.
0.10 THICKNESS WALL

SEAL WITH
SIKAFLEX-241/291

D2575 CAP

D3846-11
GASKET

D3847-11
WEARPAD

AN3C4A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

MS27039C4-08 SCREW
NAS1149C0463R WASHER
D3672-3 WASHER
12 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø0.197
8 PL PER SIDE
REF

BORE OUT END
OF SKIDTUBE TO
0.75 DEPTH TO FIT
D2575 CAP TO MIN.
0.10 THICKNESS WALL

D2575 CAP

SEAL WITH
SIKAFLEX-241/291

AN3C4A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
(1 PER SIDE)

D3846-1
GASKET
8 PL

D3847-1
WEARPAD
8 PL

AN3C5A BOLT
NAS1149C0332R WASHER
36 PL

PLUG INSERTS WITH
AN3C5A BOLT
NAS1149C0332R WASHER
6 PL

D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD
(MAKE FROM D3905-11 SKIDTUBE)

PRELIMINARY ISSUE
PH 09.05.03

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
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MFG. APPR.	PH	D3905	SHEET 2 OF 8
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DE APPR.	PH	A119 FLOAT SKIDTUBE ASSY	NTS
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BORE OUT END
OF SKIDTUBE TO
0.75 DEPTH TO FIT
D2575 CAP TO MIN.
0.10 THICKNESS WALL

SEAL WITH
SIKAFLEX-241/291

D2575 CAP

D3846-11
GASKET

D3846-1
GASKET

D3847-11
WEARPAD

AN3C4A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
2 PL

MS27039C4-08 SCREW
NAS1149C0463R WASHER
D3672-3 WASHER
12 PL

BLACK ANTI-SKID TO 0.5
ABOVE LOCATION RIDGE
TYP

11
Ø 0.197
8 PL PER SIDE
REF

BORE OUT END
OF SKIDTUBE TO
0.75 DEPTH TO FIT
D2575 CAP TO MIN.
0.10 THICKNESS WALL

D2575 CAP

SEAL WITH
SIKAFLEX-241/291

AN3C4A BOLT
D3672-1 PHENOLIC WASHER
NAS1149C0332R WASHER
2 PL

D3847-049
AFT WEARPLATE ASSY

D3847-045
CENTER WEARPLATE ASSY

D3847-043
FWD WEARPLATE ASSY

AN3C5A BOLT
NAS1149C0332R WASHER
42 PL

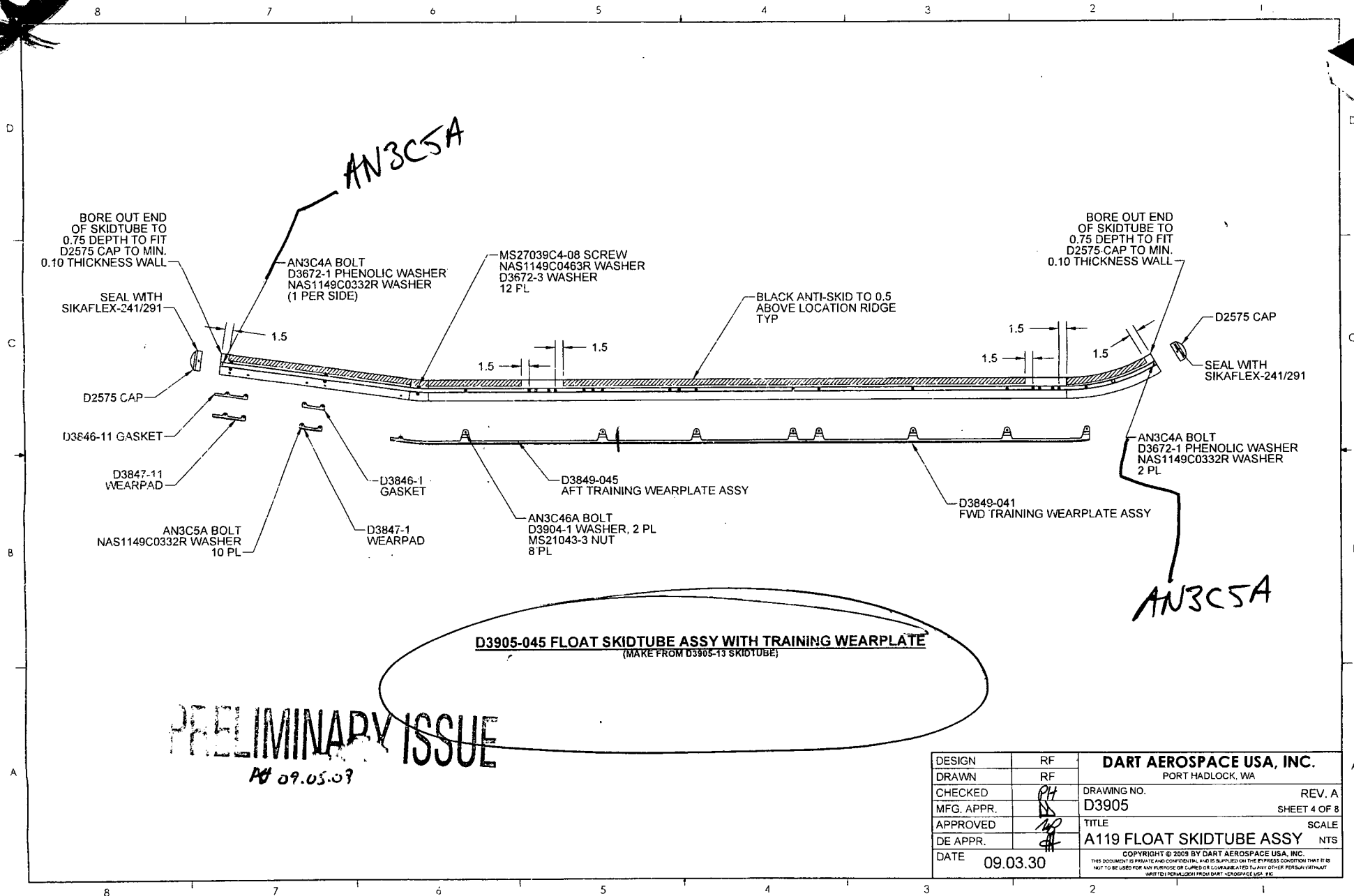
D3847-1
WEARPAD
8 PL

D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE
(MAKE FROM D3905-11 SKIDTUBE)

PRELIMINARY ISSUE
09-05-03

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2.550 .30 gap Endorel



8

7

6

5

4

3

2

1

D

C

B

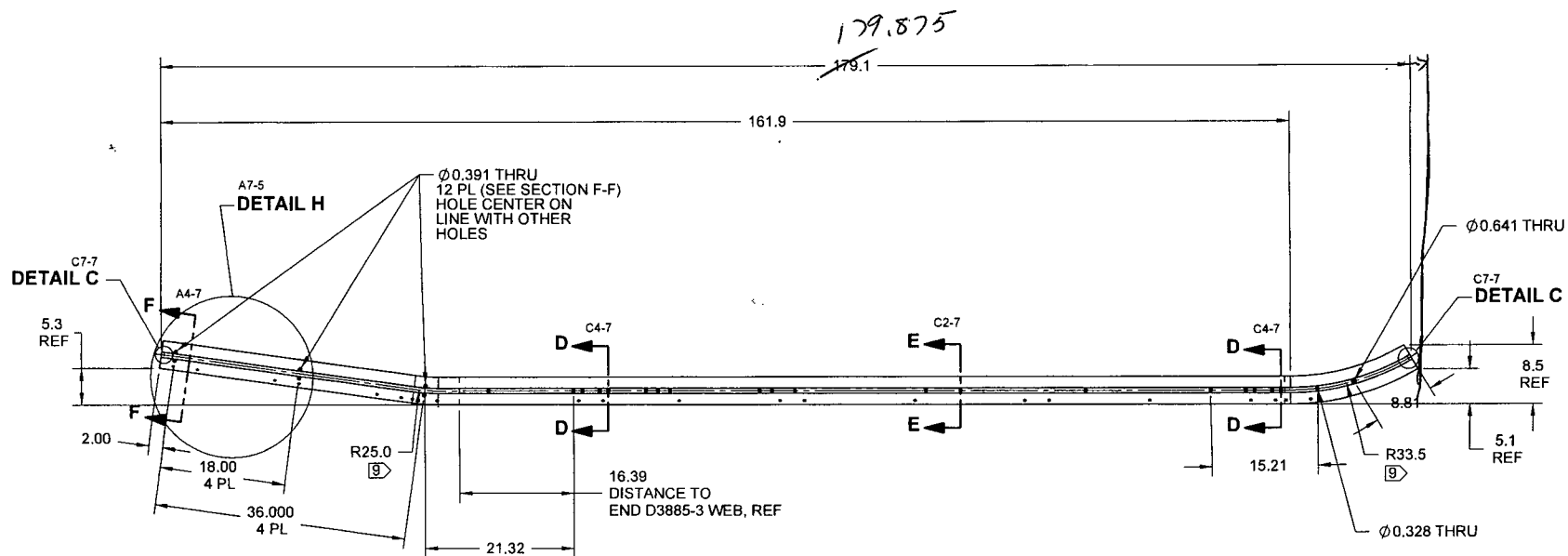
A

D

C

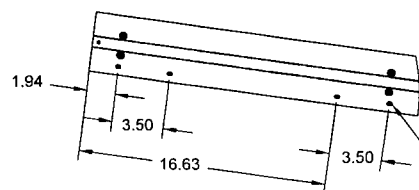
B

A



D3905-11 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

PRELIMINARY ISSUE
18 09 25-08



DETAIL H
SCALE 2X C7-5

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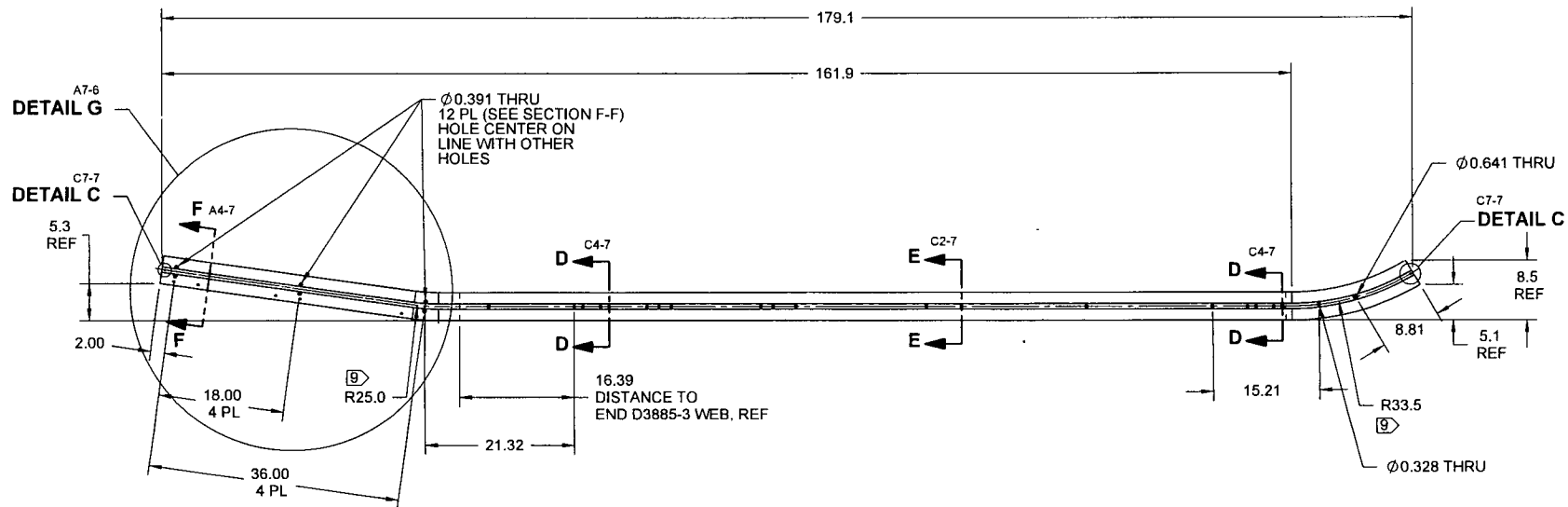
8 7 6 5 4 3 2 1

D

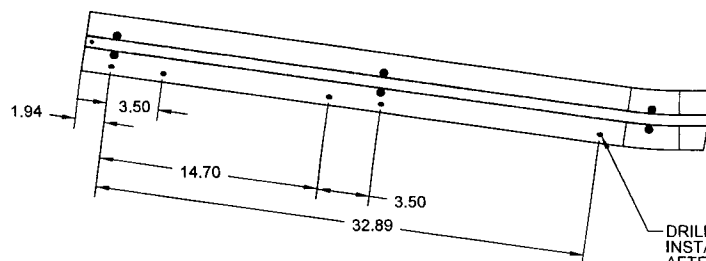
C

B

A



D3905-13 FLOAT SKIDTUBE
(MAKE FROM D3905-1 TUBE)

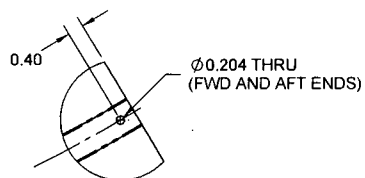


DETAIL G
SCALE 2X C8-6

PH 09.05.03
PRELIMINARY ISSUE

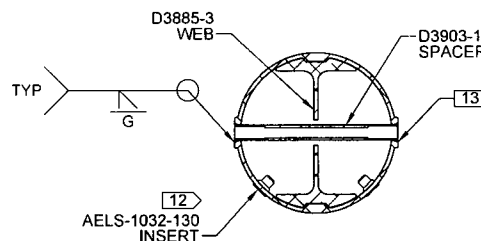
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MFG. APPR.	<i>PH</i>	D3905	SHEET 6 OF 8
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DE APPR.	<i>PH</i>	A119 FLOAT SKIDTUBE ASSY	NTS
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8 7 6 5 4 3 2 1



DETAIL C
SCALE 4X

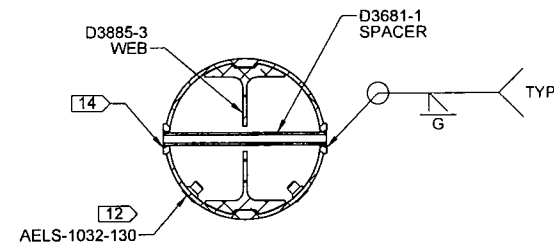
C1-5
C8-5
C8-6
C1-6



SECTION D-D
SCALE 4X

(FOR 12 x $\phi 0.375$ HOLES
PER SKIDTUBE)

C5-5
C2-5
C5-6
C2-6



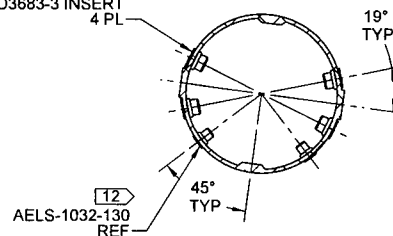
SECTION E-E
SCALE 4X

(FOR 8 x $\phi 0.328$ HOLES
PER SKIDTUBE)

C4-5
C4-6

PH 09.05.03
PRELIMINARY ISSUE

DRILL $\phi 0.391$
INSTALL D3683-3 INSERT
4 PL



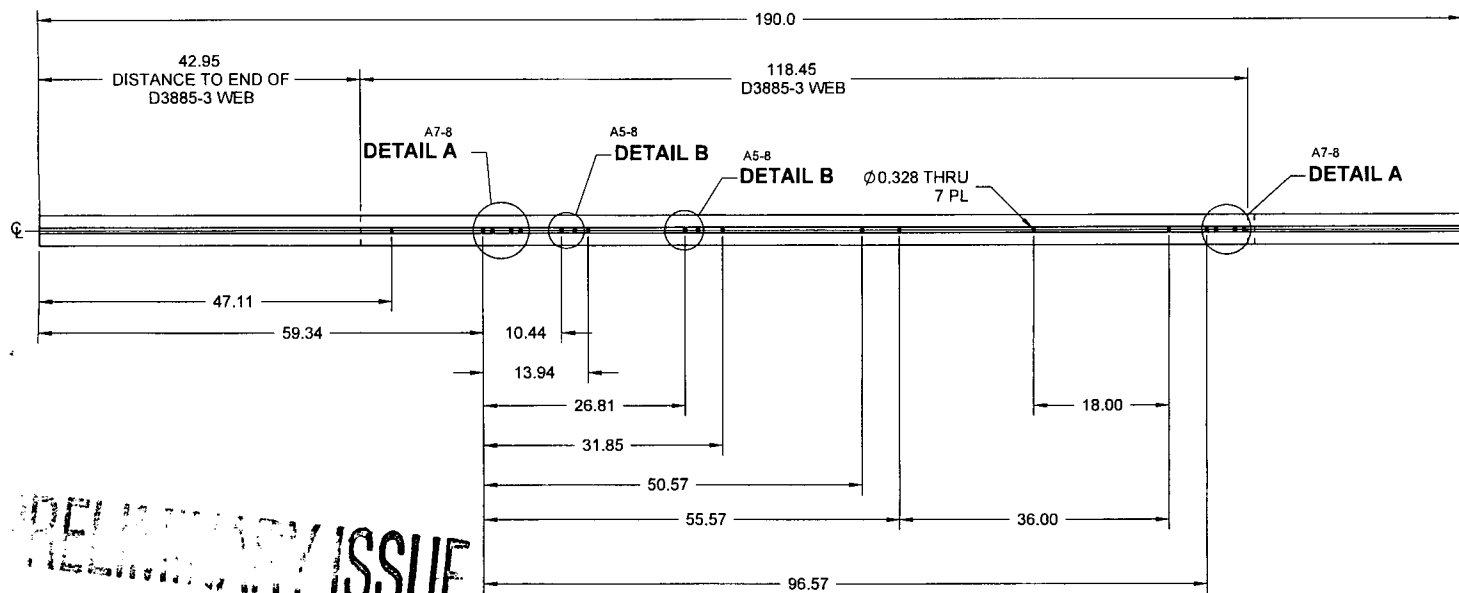
SECTION F-F
SCALE 4X

C7-6
C7-5

NOTES:

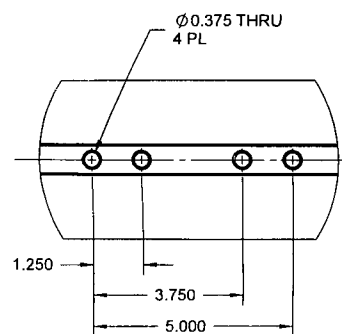
- 13) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$ HOLES ONLY:
i) CHAMFER HOLES $\phi 0.475 \times 45^\circ$ (BOTH SIDES)
ii) INSERT D3903-1 SPACER
iii) WELD INTO PLACE AND GRIND FLUSH
iv) C'BORE TO 0.313×0.75 DEEP
v) DEBURR HOLES
- 14) AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.328$ HOLES ONLY:
vi) CHAMFER HOLES $\phi 0.428 \times 45^\circ$ (BOTH SIDES)
vii) INSERT D3681-1 SPACER
viii) WELD INTO PLACE AND GRIND FLUSH
ix) DEBURR HOLES

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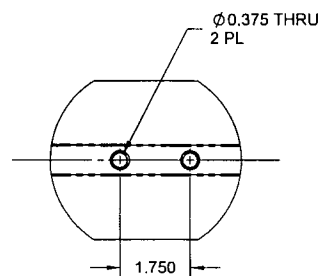


RELINQUISH ISSUE
09.05.07

D3905-1 TUBE
(MAKE FROM D2500-1-190 EXTRUSION)



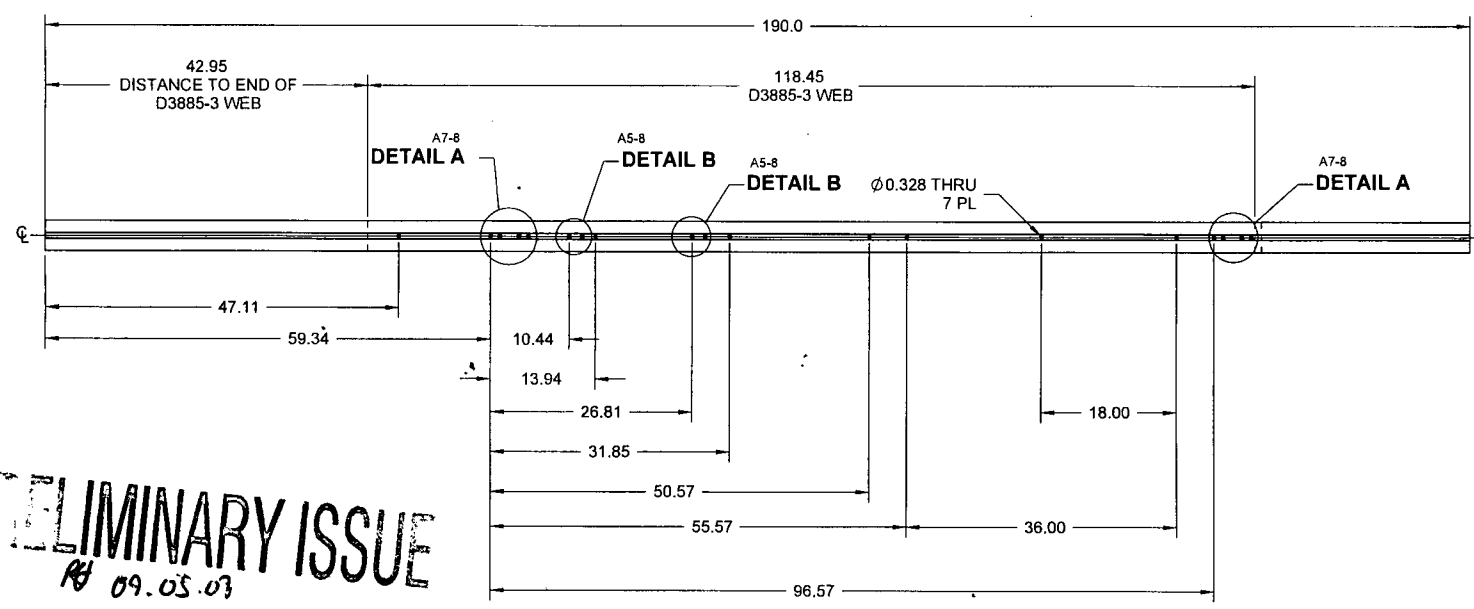
DETAIL A
SCALE 4X
D6-8
D2-8



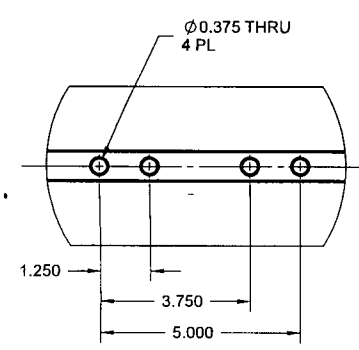
DETAIL B
SCALE 4X
D5-8
D4-8

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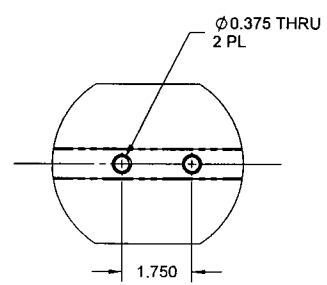
PRELIMINARY ISSUE
 09.05.07



D3905-1 TUBE
 (MAKE FROM D2560-1-190 EXTRUSION)



DETAIL A
 SCALE 4X
 D6-8
 D2-8



DETAIL B
 SCALE 4X
 D5-8
 D4-8

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APPROVED	JP	TITLE	SCALE
DE APPR.	JH	A119 FLOAT SKIDTUBE ASSY	NTS
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